

Work Order ID 60935

July 27, 2010 11:37:01 AM



Page 1

Item ID: D5957

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, 205

Start Date: 7/27/10 Start Qty: 4.00



Cust Item ID:

Required Date: 8/06/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D5957

Rev B

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

DT 10/08/05

HAAS CNC vertical machine #1

1-Machine as per folio D5957, Ensure Batch Number is entered ☐ 2-Machine
Keyway ☐ 3-Deburr & Tumble

4 *Ø*

110

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

DT 10/08/05

4 *Ø*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

10.8.7

4

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

M 10/08/09

4

0



HandFinish

Memo

0.00

Hand Finishing

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

1115291

0.00

M 10/08/10

4

0



Powdercoat

Memo

Powder Coating

START TIME:

1:00pm

OVEN TEMPERATURE:

1:30pm FINISH TIME:

320°F

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

M

10

08

10

(4)

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Page 3

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 130

0.00



Packaging

Memo

0.00

Packaging

10/8/10 SL 40

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/8/11 JF

MF

10-8-11

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Picklist Print

July 27, 2010 11:37:00 AM

Page 1

Work Order ID: 60935



Parent Item: D5957



Parent Item Name: Saddle, 205

Start Date: 7/27/10

Required Date: 8/06/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:E Re-Format 05-11-29 JLM
IPP Rev:F ecn826 06.12.06 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			110	Each	60.0000	1	4			
Saddle Billet													

Location

Loc Qty

Loc Code

MAT

14

59621

14

MAT42

46

46412

2

58677

4

60314

40

4 10/08/01

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DART AEROSPACE LTD		Work Order: 60935
Description: Inner Aft Saddle		Part Number: D5957
Inspection Dwg: D5957	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.441	0.441	0.441	0.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		2.250	2.250	2.250	2.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		0.321	0.321	0.321	0.321		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		0.321	0.321	0.321	0.321		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.501	0.499	0.500	0.501		
N	1.865	1.885		1.875	1.875	1.875	1.875		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.308	0.313		0.313	0.313	0.311	0.311		
R	0.760	0.765		0.762	0.762	0.762	0.762		
S	0.490	0.510		0.493	0.494	0.494	0.494		
T	1.625	1.645		1.628	1.631	1.638	1.638		
U	2.000	2.020		2.000	2.001	2.005	2.005		
V	0.023	0.043							
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: DJP	Audited by: [Signature]
Date: 10/08/05	Date: 10.8.9

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.09.05	Dimension K revised	KJ/DD	
H	09.07.29	Dimension Q revised	KJ	[Signature]

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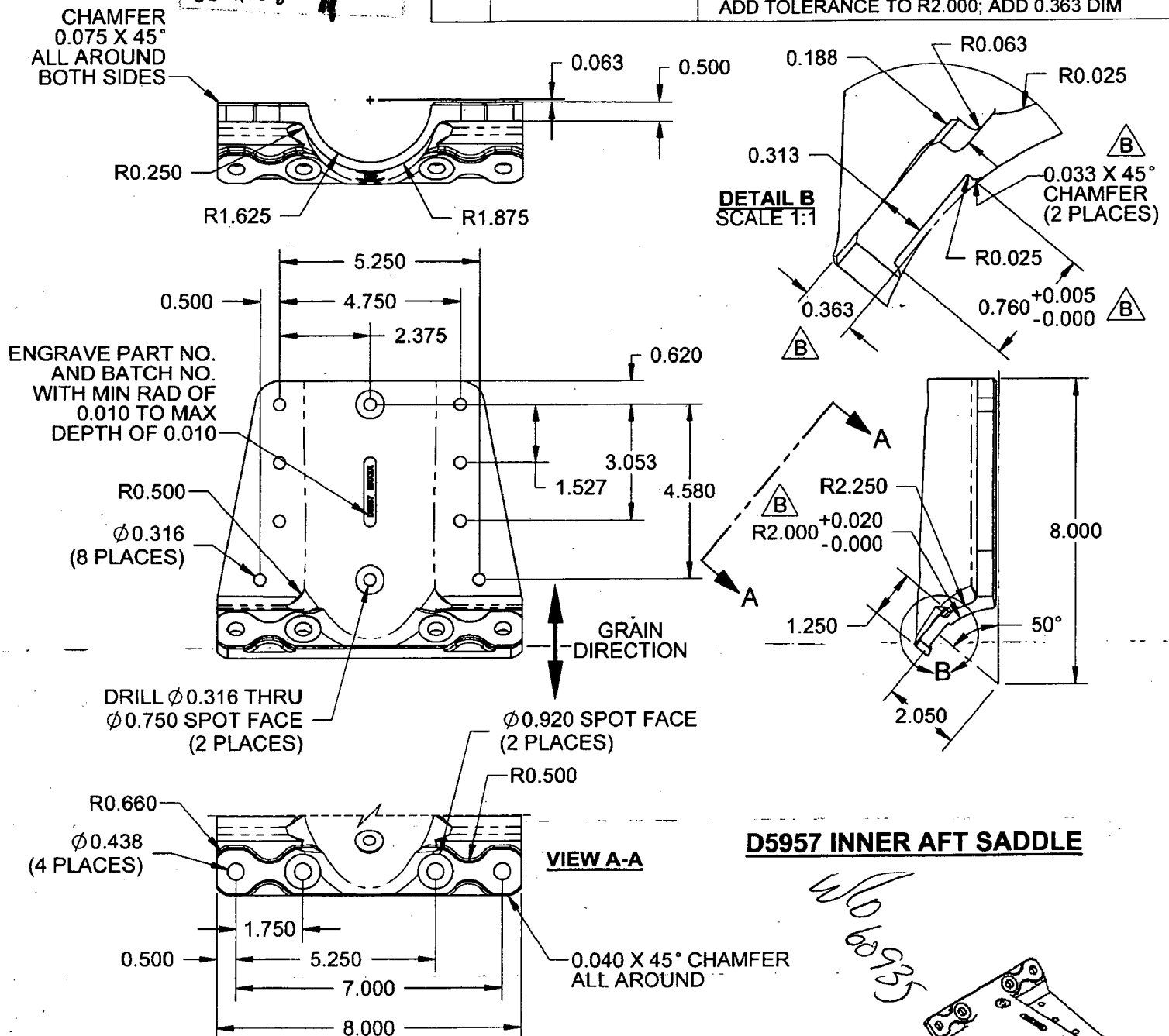
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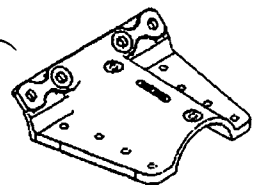
NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D5957	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE INNER AFT SADDLE		
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020



ISOMETRIC VIEW
SCALE 1:8

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